

Work Order ID 79178

January-23-12 10:45:54 AM

79178

Page 1

Item ID: D2803-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 23/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/23 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2803	Rev B								

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Fit d2803-2								
6061 .500X 10.	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio FA102								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

1B12-1-25

(10)

1B12-1-25

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00	B.A	12/01/29		10	0		
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
145	QC3- Inspect Part Finish	0.00							
145									
QC	Memo	0.00							
Quality Control									

10 12-1-31

10 X 10 M 12/01/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>148</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/2/2 54 10
 12/2/2
 012-022
 10

W/O:		WORK ORDER CHANGES					
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Picklist Print

January-23-12 10:45:58 AM

Page 1

Work Order ID: 79178

79178

Parent Item: D2803-2

D2803-2

Parent Item Name: Bracket

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 00.11.06New IssueEC
IPP Rev:B Blanks now cut on Waterjet 06-06-14 JLM
IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC IPP
Rev:D add qc3 DD 10.02.19 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased	No			100	f	24.1000	1.9167	20.17579			

M6061T6B0 500X10 000

6061-T6 Bar .500 x 10.00

**

B 12-1-25

Location

Loc Qty

Loc Code

MAT004

24.1

119513

24.1

119513

(10)

~~118611~~

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	79178
Description: Bracket		Part Number:	D2803-2
Inspection Dwg: D2803	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.758	✓		Dim. Caliper	36 05
1.420	+/-0.001	1.420	✓			
Ø0.191	+0.005/-0.000	.191	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
Ø0.507 x 0.250	+0.000/-0.001	.5065 / .245	✓			
12.411	+/-0.010	12.411	✓			
6.933	+/-0.010	6.933	✓			
0.250	+/-0.010	.252	✓			
0.875	+0.000/-0.001	.8745	✓			
0.250	+0.000/-0.005	.247	✓			
0.125	+/-0.010	.126	✓			
0.125	+/-0.010	.127	✓			
0.500	+/-0.010	.502	✓			
0.125	+/-0.010	.130	✓			
0.188	+/-0.010	.188	✓			
0.562	+/-0.010	.564	✓			
0.125	+/-0.010	.130	✓			

Measured by:	36/R
Date:	12/01/29

Audited by:	DA
Date:	12/01/29

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.12.07	13.558 dimension removed	KJ/JLM	
C	08.01.16	Tolerance revised for 0.875 dimension	KJ/EC/DD	

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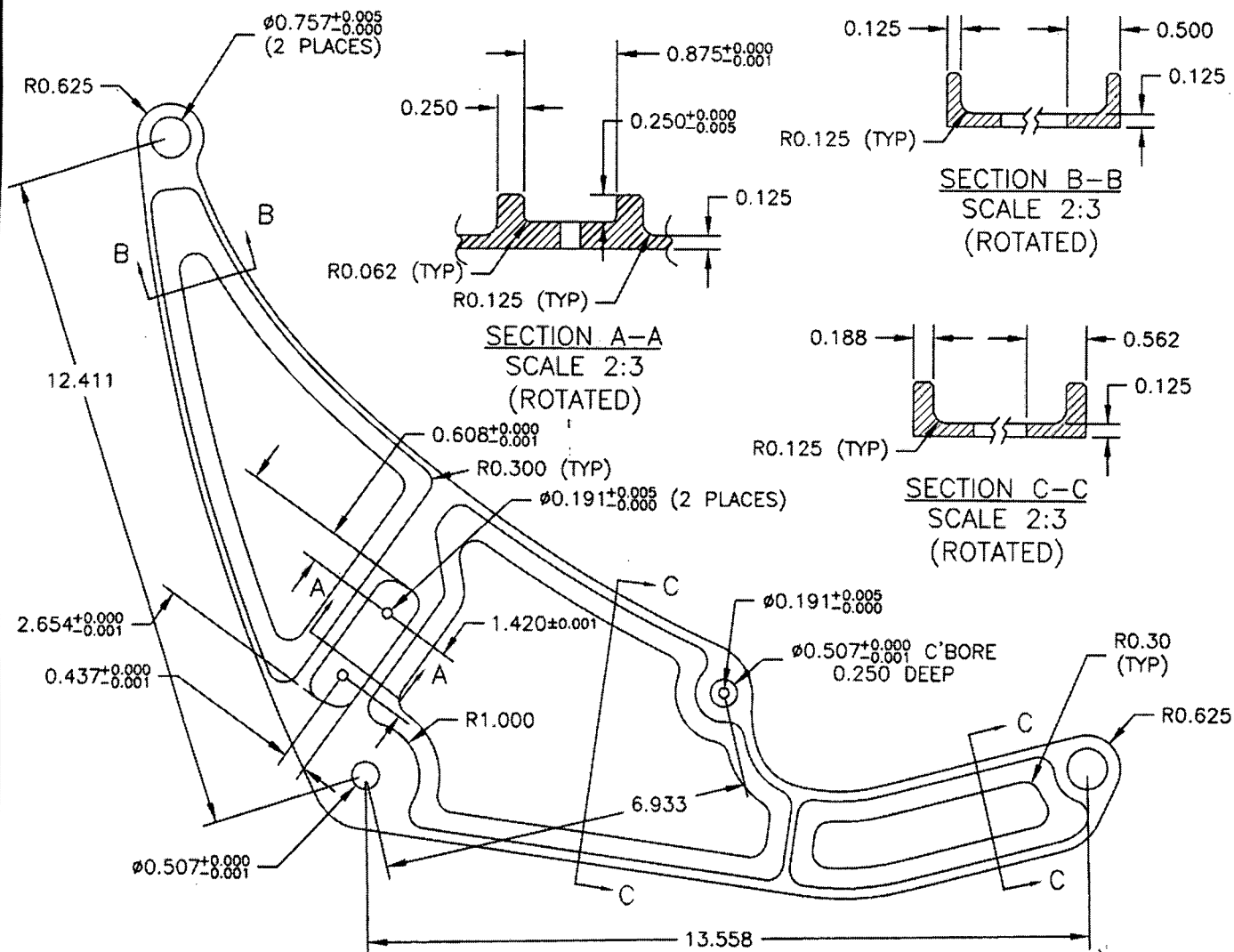
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11



D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTICE
WORK COPY

79178
M.C.J. 12/01/22

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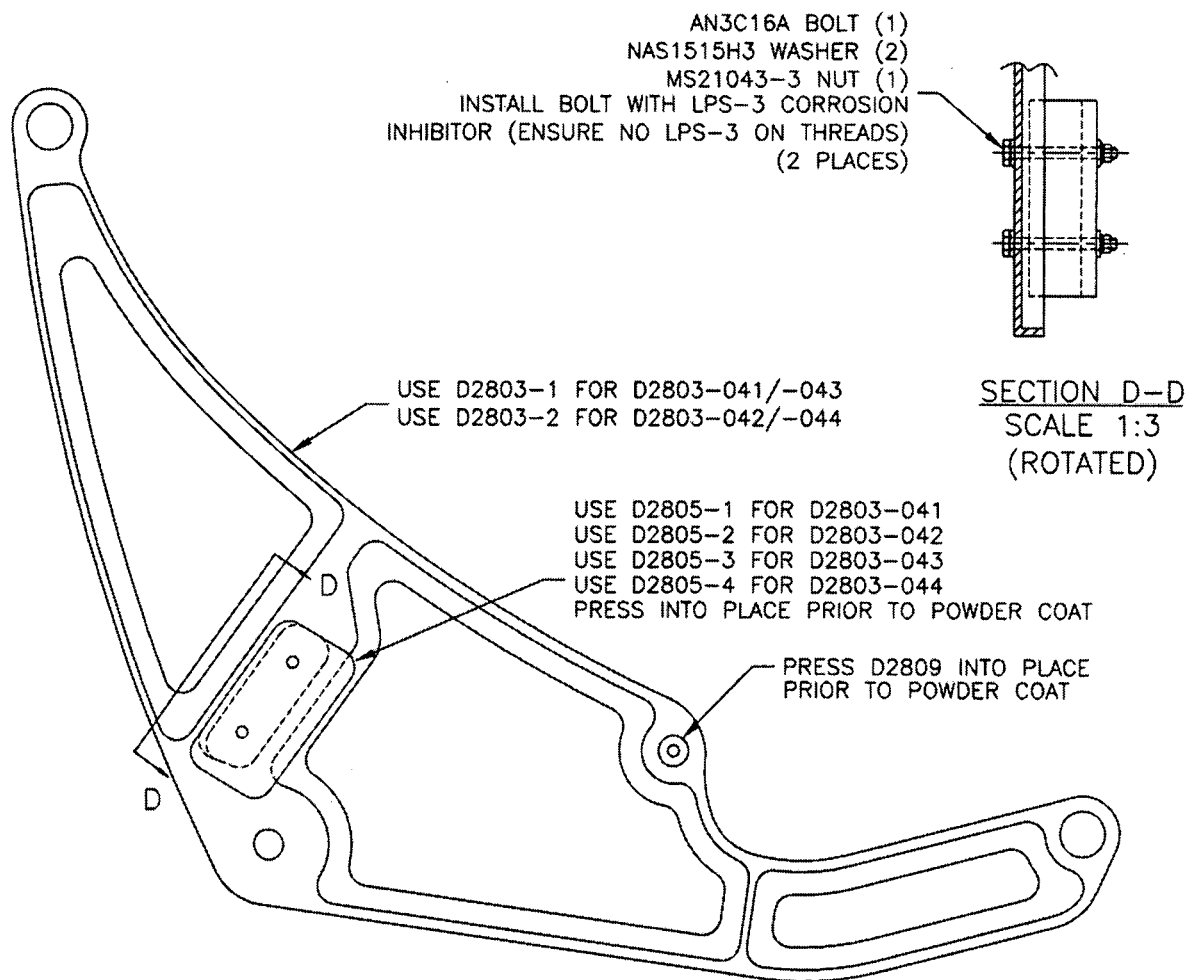
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03-11 [Signature]

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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